

Date: Thursday, 2/21/2008 9:26:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 37566	
Estimate Number : 10533	
P.O. Number :	Part Number : D2573
This Issue : 2/21/2008 S.O. No. :	Drawing Number : D2573 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 37552	Material :
Written By :	Due Date : 3/15/2008 Qty: 6 Um: Each
Checked & Approved By : <u>08 02 21</u>	
Comment : Est: 1 As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

D6101007

D6101007

7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: B34875

08/02/27

6

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 37566 Double check by: DJP

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

08/03/04 (6)

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

08/03/04 (6)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/03/04 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 28/03/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 37566

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Handwritten signature
08-03-05

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Handwritten initials

08-03-06 (6x)

7.0

POWDER COATING

POWDER COATING



M107005



(6x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten signature 08/03/06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-03-06

(6x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 433

Handwritten signature 08/03/06

(6x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/07

Job Completion



Handwritten signature 08/03/07

(6)

DART AEROSPACE LTD	Work Order:	37566
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

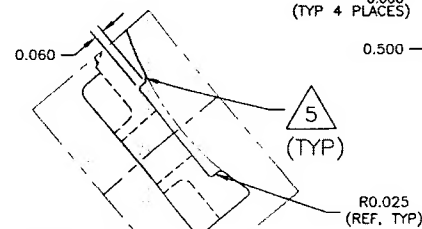
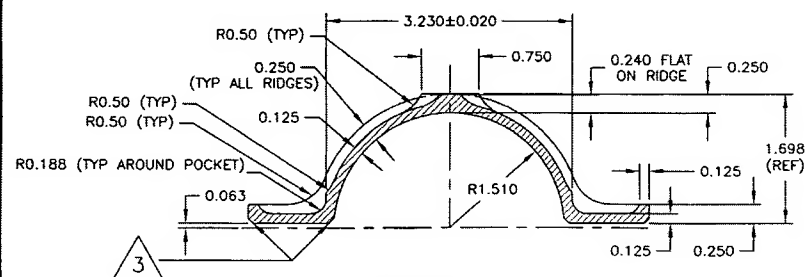
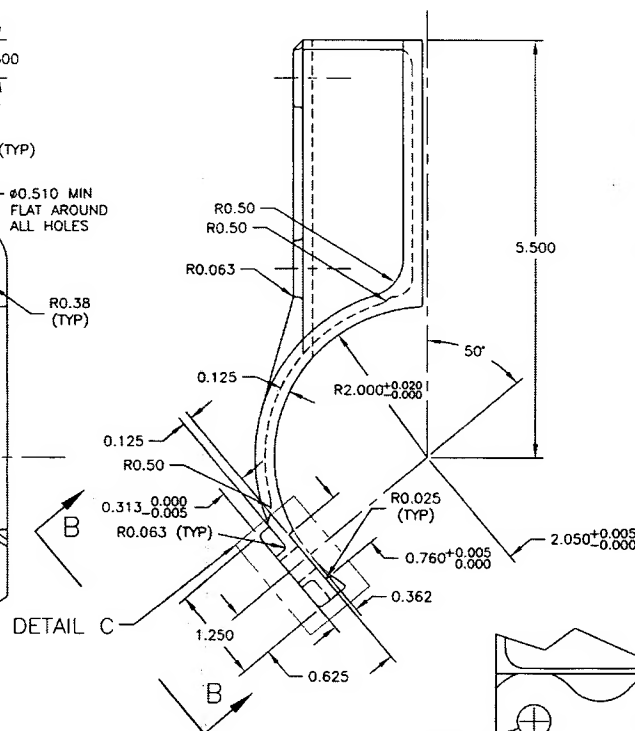
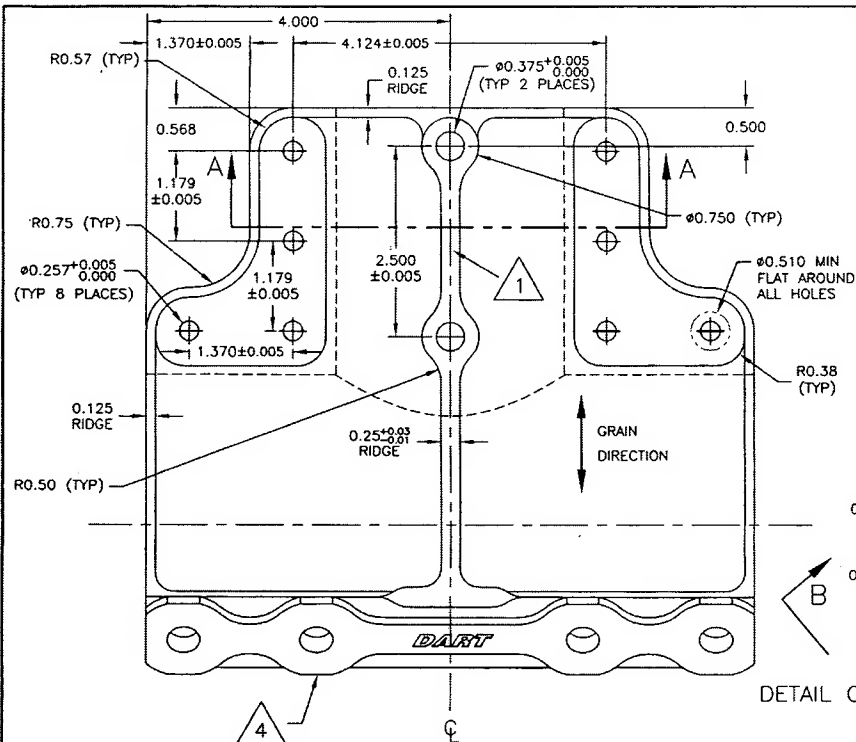
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.004	8.004				
F	0.490	0.510		.502	.503				
G	0.257	0.262	DT8683	.258	.258				
H	0.375	0.380	DT8684	.376	.376				
I	0.490	0.510		.503	.502				
J	1.174	1.184		1.175	1.175				
K	0.558	0.578		.571	.570				
L	1.174	1.184		1.175	1.175				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.126	.126				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.254	.254				
S	0.115	0.135		.126	.125				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.228	3.228				
V	0.230	0.250		.243	.243				
W	0.115	0.135		.127	.127				
X	0.308	0.313		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.369	.370				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.628	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.254	.254				
AE	1.500	1.520		1.515	1.515				
AF	0.115	0.135		.135	.133				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.253	.253				
AI	2.000	2.020		2.004	2.003				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	SA
Date:	08/03/04

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	






05.12.06



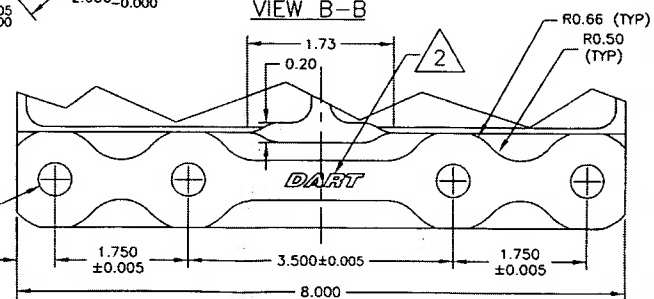
DETAIL C
SCALE 4:3



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		DRAWN BY
DS	PH	DART DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2573
DATE 05.07.13		TITLE OUTER AFT SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

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WORK ORDER
NO. 3756